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K6A 1K7
Canada

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008383

D4634-145
Job Sheet 186151



Part No: D4634-145

Job Qty: 1 pcs

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV G SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	12/7/18		0.00	1.47	Small Fab - 1		DAS 58 9-89 MAR 12 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	12/7/18		0.00	0.00	QC 5 - 10		PD 19.03.13
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/7/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

Packaging 3 - 6 - B4B	DAS
Packaging 3 - 7 - B4B	58 MAR 13 2019
Packaging 3 - 8 - B4B	9-89
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	

140 QC 21 - SA	1 pcs	12/7/18	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	MAR 13 2019 70

Part Op 110 - Small Fab (Small Fab) Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 9309
 Descriptions: Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____
 120 - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O
 130 - Packaging3 (Identify as per dwg & Stock Location: _____) Identify as per dwg & Stock Location: _____
 140 - QC21 (QC21- Final Inspection - Work Order Release)QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-5	Aft, Center Ceiling Panel	1 pcs (1 ea)	110-Small Fab - 1	5131092
D4636-5	Bracket	1 pcs (1 ea)	110-Small Fab - 1	5122035
D4647-1	Doubler	1 pcs (1 ea)	110-Small Fab - 1	5113182
D4664-5	Spacer	6 pcs (6 ea)	110-Small Fab - 1	5132129
D4712-1	Bracket	1 pcs (1 ea)	110-Small Fab - 1	5008996
D4732-17	Label	1 pcs (1 ea)	110-Small Fab - 1	5104121
D4732-23	Label	1 pcs (1 ea)	110-Small Fab - 1	5123737
D4732-27	Label	1 pcs (1 ea)	110-Small Fab - 1	5113570
D5021-5	Foam, Center Panel, Aft	1 pcs (1 ea)	110-Small Fab - 1	5035157
MPNY-750S-9-C	Mounting Pad	9 pcs (9 ea)	110-Small Fab - 1	fm1304237
MS20426AD3-4	Rivet	4 Ea (4 ea)	110-Small Fab - 1	50811364/442-1
MS20426AD4-6	Rivet	2 Ea (2 ea)	110-Small Fab - 1	5093088-1
MS21059L08	Nut	2 Ea (2 ea)	110-Small Fab - 1	5033756

fg 234
 ST108
 mfo04
 mfo04
 mfo04
 mfo05
 mfo05
 mfo05
 mfo05
 fg 234
 ST570
 GA006
 GA007
 ST300

CCR26455-3-04 X4

5157070
 103952

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	D4634-5	1	4	0
	D4636-5	1	63	0
	D4647-1	1	7	0
	D4664-5	6	43	0
	D4712-1	1	8	0
	D4732-17	1	16	0
	D4732-23	1	18	0
	D4732-27	1	3	0
	D5021-5	1	3	0
	MPNY-750S-9-C	9	152	0
	MS20426AD3-4	4	3,547	0
	MS20426AD4-6	2	1,387	0
	MS21059L08	2	171	0
Part Specifications				
Specifications could not be found.				

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D4634-145
Job Sheet 186151



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description:

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REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Small Fab		
110	Small Fab	1 pcs		12/7/18	0.00	1.47	Small Fab		
120	QC	1 pcs		12/7/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3		
140	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300
Descriptions: Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with
wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see
note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M
3950 edge sealer(see note 9) Batch: _____
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4634-5	Aft, Center Ceiling Panel	1 Ea (1 ea)	90-Start up Operation	
D4636-5	Bracket	1 Ea (1 ea)	90-Start up Operation	
D4647-1	Doubler	1 Ea (1 ea)	90-Start up Operation	
D4664-5	Spacer	6 Ea (6 ea)	90-Start up Operation	
D4712-1	Bracket	1 Ea (1 ea)	90-Start up Operation	
D4732-17	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-23	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-27	Label	1 Ea (1 ea)	90-Start up Operation	
D5021-5	Foam, Center Panel, Aft	1 Ea (1 ea)	90-Start up Operation	
MPNY-750S-9-C	Mounting Pad	9 pcs (9 ea)	90-Start up Operation	
MS20426AD3-4	Rivet	4 Ea (4 ea)	90-Start up Operation	
MS20426AD4-6	Rivet	2 Ea (2 ea)	90-Start up Operation	
MS21059L08	Nut	2 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4634-5	1	1	0
	D4636-5	1	79	0
	D4647-1	1	9	0
	D4664-5	6	21	0
	D4712-1	1	17	0
	D4732-17	1	12	0
	D4732-23	1	12	0
	D4732-27	1	5	0
	D5021-5	1	3	0
	MPNY-750S-9-C	9	187	0
	MS20426AD3-4	4	4,518	0
	MS20426AD4-6	2	1,775	0
	MS21059L08	2	122	0

Part Specifications

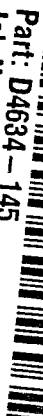
Specifications could not be found.

Plex 11/12/18 11:31 AM dart.white.jesse



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Container No: S162026



Part: D4634-145

Job No: 186151

Serial No/Batch: S162026

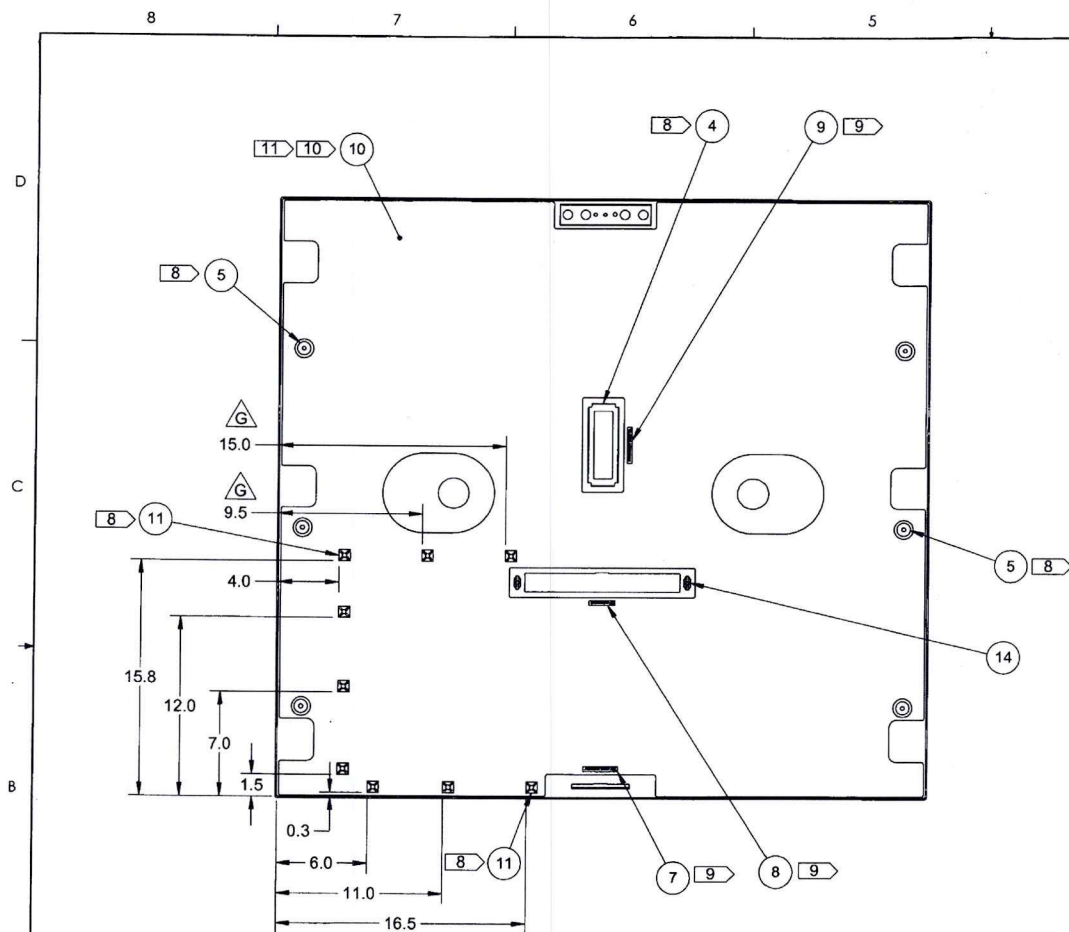
Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/13/19

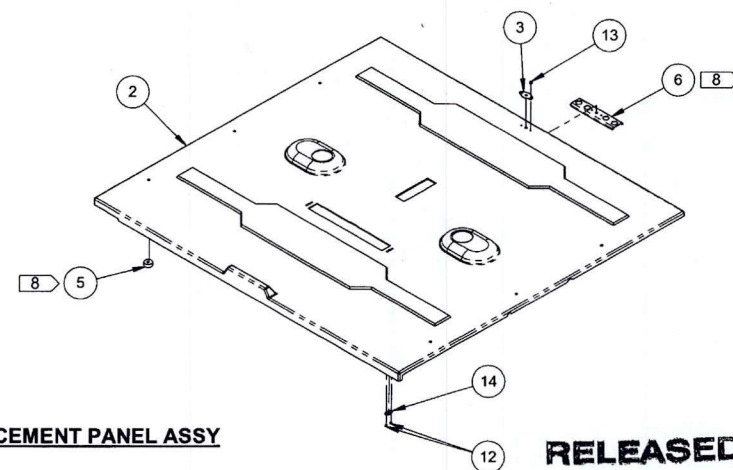


D4634-145 AFT, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-5 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-5 FOAM ON D4634-5

ITEM	QTY -145	P/N	DESCRIPTION
1	X	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-5	AFT, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-17	LABEL
8	1	D4732-23	LABEL
9	1	D4732-27	LABEL
10	1	D5021-5	FOAM, CENTER PANEL, AFT
11	9	MPNY-750S-9-C	MOUNTING PAD
12	4	MS20426AD3-(4)	RIVET, SOLID, CSK
13	2	MS20426AD4-(6)	RIVET, SOLID, CSK
14	2	MS21059L08	NUT PLATE



RELEASED
2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 9 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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